

## Patent Claims

1. Method for producing blanks from cardboard (1a, b, c) or board-like materials for product sales purposes, whereby the workpieces originally of any initial shape are blanked by longitudinal (2) or transverse (3) cut lines, as the case may be, into the layout of a box structure (4) to be manufactured, and also have other processing lines (5a, 5b) that run in neither the longitudinal nor the transverse directions, **characterized by the fact that** the other processing lines (5a, 5b) that run in neither the longitudinal nor the transverse directions are produced by a processing device (7) movable parallel to and relative to the plane of the material to be blanked, that can be caused to travel at a prescribed distance (10) from the material to any point on this processing line, and activated for processing, and is driven (11, 12) in the activated state along the processing lines (5a, 5b) with controlled (13, 14, 19) feed in the processing direction.
2. Method pursuant to Claim 1, **characterized by the fact that** the other processing lines (5a, 5b) are produced in a process step prior to the processing steps for producing the longitudinal and transverse cut lines (2, 3) as the case may be.
3. Method pursuant to Claim 1 or 2, **characterized by the fact that** the other processing lines (5a, 5b) are produced in a process step that follows in time the production of the longitudinal and transverse cut lines (2, 3).
4. Method pursuant to one of the claims 1 to 3, **characterized by the fact that** the other processing lines (5a) are cut lines that are produced by a processing device designed as a cutter (20).
5. Method pursuant to Claim 4, **characterized by the fact that** the other cut lines (5a) are continuous except for predetermined hold points (16), with the hold points fastening the chip (17) to the rest of the blank (18).
6. Method pursuant to Claim 5, **characterized by the fact that** the other cut lines (5a) are produced by a cutter (20) controlled digitally by an associated EDP system (19).

7. Method pursuant to one of the claims 1 to 6, **characterized by the fact that** the other processing lines (5b) comprise adhesive points and that the processing device (7) is an adhesive device (21).
8. Method pursuant to Claim 7, **characterized by the fact that** the adhesive device (21) is digitally controlled by an associated EDP system (19) and includes an adhesive applicator (22) that can be made to travel to any point on the blank (1a, b, c) and can be activated in the sense of discharging adhesive.
9. Method pursuant to Claim 8, **characterized by the fact that** the adhesive applicator (22) can be activated pointwise.
10. Method pursuant to one of the claims 7 to 9, **characterized by the fact that** the adhesive applicator (22) remains activated during the controlled travel motion.
11. Method pursuant to one of the claims 1 to 6, **characterized by the fact that** the other processing lines are crease, perforation, milled, or marking lines that are produced with a correspondingly designed processing device, with the processing occurring along a straight-line processing path on the workpiece with preceding and following process steps, in an in-line machine.
12. Device by implementation of the method pursuant to Claim 1, **characterized by the fact that** a fixed-location processing station (40) is provided, in which the workpiece (1a, b, c) to be processed is held, and that has a processing device (7) mounted in fixed location relative to the held workpiece, with a processing head (9) that can be caused to travel to any point on the workpiece, which can be activated or deactivated depending on its particular position.
13. Device pursuant to Claim 12, **characterized by the fact that** the processing head (9) rests on two fixed-location guidance systems (24a, 24b, 25a, 25b) that are movable perpendicular to one another.

14. Device pursuant to Claim 12, **characterized by the fact that** the processing head (9) rests on a boom (26) that can be rotated and extended in the manner of a robot arm.
15. Device pursuant to one of the claims 12 to 14, **characterized by the fact that** there at least two processing heads (9, 9') that are operated in unison or at staggered times.
16. Device pursuant to one of the claims 12 to 15, **characterized by the fact that** the processing head (9, 9') has a cutter (20) pointing toward the workpiece (1a, b, c).
17. Device pursuant to Claim 16, **characterized by the fact that** the cutter (20) comprises a stationary or rotating knife.
18. Device pursuant to Claim 16, **characterized by the fact that** the cutter (20) operates by the laser, water jet, or sand jet principle.
19. Device pursuant to one of the claims 12 to 16, **characterized by the fact that** the processing head (9) carries a perforator.
20. Device pursuant to one of the claims 12 to 19, **characterized by the fact that** the processing head (9) carries a scoring or creasing device.
21. Device pursuant to one of the claims 11 to 20, **characterized by the fact that** the processing head (9) carries a marking device.
22. Device pursuant to one of the claims 12 to 21, **characterized by the fact that** the processing head (9) has a glue discharge nozzle (27) pointing toward the workpiece (1a, b, c).
23. Device pursuant to Claim 22, **characterized by the fact that** the glue discharge nozzle (27) is connected to a heater (28).

24. Device pursuant to Claim 22 or 23, **characterized by the fact that** the glue discharge nozzle is provided with a controllable (30) discharge valve (29).
25. Device pursuant to one of the claims 22 to 24, **characterized by the fact that** the fixed-location processing station (40) is followed by a pressing station (31).